



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4753-1

Job Sheet 179458



Part No: D4753-1

Job Qty: 75 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/1/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	75 Ea	7/1/18	7/1/18	0.00	0.00	Start Up Waterjet		OK 18/06/21
100	Waterjet	75 pcs	7/1/18	7/1/18	0.00	2.25	Waterjet1		OK 18/06/21
110	QC	75 pcs	7/1/18	7/1/18	0.00	0.00	QC2 Waterjet-1		OK 18/06/21
120	CNC Vertical Machining	75 pcs	7/1/18	7/1/18	0.02	5.40	HAAS1-5		SBL 15/06/24
140	QC	75 pcs	7/1/18	7/1/18	0.00	0.00	QC8		OK 18/06/24
150	Small Fab	75 pcs	7/1/18	7/1/18	0.00	0.89	Small Fab-7		DAS
160	QC	75 pcs	7/1/18	7/1/18	0.00	0.00	QC5		38
170	HandFinish	75 pcs	7/1/18	7/1/18	0.00	0.62	HandFinish1		BEB 18/06/25
180	QC	75 pcs	7/1/18	7/1/18	0.00	0.00	QC7-4		38
190	Packaging	75 pcs	7/1/18	7/1/18	0.00	0.00	Packaging3-2		9-89
200	QC21-SA	75 Ea	7/1/18	7/1/18	0.00	0.00	QC21		JUN 26 2018

Part Op 100 - 1-Cut as per Dwg D4753 Dwg Rev: A Prog Rev: A ***.758" DIA HOLE TO BE OPENED TO FIN
 Descriptions: SIZE BY SKID DEPARTMENT UPON INSTALLATION** 3- Deburr if necessary
 120 - Machine as per Folio FB163 and Dwg D3506 FOLIO REV: AA DWG REV: A ***.758" DIA HOLE
 TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**
 150 - C'sink as per Dwg D4753 (On Flat side)
 190 - LOCATION : LG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	1.0350 sf (.0138 ea)	90-Start up Operation	FM 137980 FM 138340

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	1	93	0



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S083133



Part: D4753-1

Job No: 179458

Serial No/Batch: S083133

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/21/18

2AG
38
2AG
38
38-0

2AG
38
38-0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128Inches + 0.005 - 0.001	0.133 0.127	Diameter	
2	Doubler	0.500Inches ± 0.010	0.510 0.490		
3	Doubler	1.000Inches ± 0.010	1.010 0.990		
4	Doubler	0.750Inches ± 0.010	0.760 0.740		
5	Doubler	1.500Inches ± 0.010	1.510 1.490		
6	Doubler	2.000Inches ± 0.010	2.010 1.990		
7	Doubler	0.126Inches ± 0.010	0.136 0.116		
8	Doubler	3.540Inches + 0.012 - 0.001	3.552 3.539	Diameter	
9	Doubler	0.126Inches ± 0.010	0.136 0.116		

Plex 6/19/18 1:09 PM dart.leroux.jason

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	15.03.03	New Issue	KJ	
B	17.07.13	Dimensions Ø0.758 removed	KJ	